

Work Order ID 70518

Friday, June 10, 2011 2:51:39 PM



Page 1

Item ID: D3601-1

Accept



Setup Start



Revision ID:

Item Name: Radius Block

Stop



Start Date: 6/10/2011 Start Qty: 24.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 24.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3601	Rev A

100		0.00							
	SHEAR								
Shear	Memo	0.00							
Shear	blanks 9.00" long +/- 0.030" □ Note: 1 blank makes 8 pieces								

SL 11/06/29

24

110		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1- Mill as per Folio FA682 Rev: AA & Dwg D3601 Rev: A								

SMR 11/06/30

24

120		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

SMR 11/06/30

24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




Work Order ID 70518

Friday, June 10, 2011 2:51:40 PM

Page 2

Item ID: D3601-1 Accept  Setup Start 
Revision ID: Stop 
Item Name: Radius Block
Start Date: 6/10/2011 Start Qty: 24.00  Cust Item ID:
Required Date: 6/15/2011 Req'd Qty: 24.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		BA 11/06/30		24	0		
140  Small Fab Small Fab	Small Fab Memo 1-Tumble 2-Deburr any rough edges after tumbling	0.00 0.00						BA-7-5	(74)
150  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				24	0		24 0 24 6/10/2011

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NOTE: Date & initial all entries

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Page 3

Item ID: D3601-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Radius Block

Start Date: 6/10/2011 Start Qty: 24.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 24.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

24x2 M-11/07/05

170

Identify as per dwg & Stock Location: ST69

0.00



Packaging

Memo

0.00

Packaging

JB/6/7/6 (24)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/06

MP

11-07-06

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, June 10, 2011 2:51:46 PM

Page 1

Work Order ID: 70518

Parent Item: D3601-1

Parent Item Name: Radius Block



Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP Rev:A New Issue 07-03-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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~~M5052H32B0.125X00.~~
75

Purchased

No

100

f

0.0000

0.06666

1.684042



~~5052-H32 Bar .125 x .750~~



SL 11/06/29

1.7

M606/T6B00750X00125

for 11.06.06

M 116406

not in computer



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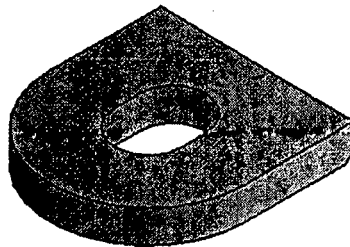
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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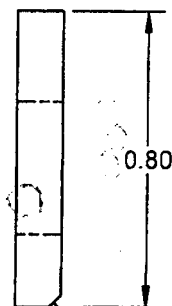
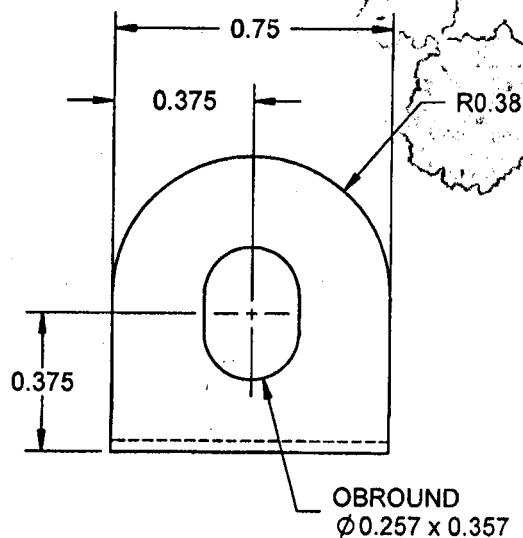
NOTE: Date & initial all entries

DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3601	REV. A SHEET 1 OF 1
DATE 07.02.13		TITLE RADIUS BLOCK SCALE 2:1	
REV A	DATE 07.02.13	DESCRIPTION NEW ISSUE	

RELEASED07.03.08 **[Signature]**

SI
SHOP COPY
E
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **10518**



CHAMFER 0.05
0.03 x 45° OR
FILLET R 0.05
0.03

D3601-1 RADIUS BLOCK**NOTES:**

- 1) MATERIAL: ALUMINUM 5052-H32 SHEET, 0.125 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.125) OR ALUMINUM 6061-T6 SHEET, 0.125 THICK PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N D3601-1 USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.050 MAX

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Dart Aerospace Ltd

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